

# Work Order ID 80594

\*80594\*

Page 1

February 23 12:25:25 PM

Item ID: D4275-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd Beam

Start Date: 24/02/2012 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: M.L.S

Date: 12/02/23 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4275	A

100

\*100\*

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank to 39.750"

Batch: 5

0.00

0.00

PO 12/02/27

12/03/03

2 0

110

\*110\*

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB006

DWG REV: A

FOLIO REV: AA

0.00

0.00

12-03-03

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80594

February-23-12 2:51:25 PM

**\*80594\***

Page 2

Item ID: D4275-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fwd Beam  
 Start Date: 24/02/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 09/03/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00	SL	12-03-03		(2)			
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	ml	12/03/03		2	0		
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				2	0		(2P) 12/03/05

W/O:		WORK ORDER CHANGES					
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**Work Order ID 80594****\*80594\***

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February-23-12 2:51:25 PM

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Revision ID: Stop **\*NS2\***  
Item Name: Fwd Beam  
Start Date: 24/02/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
Required Date: 09/03/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

me  
12-03-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

February-23-12 2:51:29 PM

Page 1

Work Order ID: 80594

\*80594\*

Parent Item: D4275-1

\*D4275-1\*

Parent Item Name: Fwd Beam

Start Date: 24/02/2012

Required Date: 09/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP  
rev:B 10.12.02 AS PER DWG REV.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	71.8628	3.3125	6.973684			

\*M6061T6B1 000X04 000\*

6061-T6 Bar 1.00 x 4.00

\*\*

PD 12/02/27

Location

Loc Qty

Loc Code

MAT004

24

116808

0.787

118400

15.003

119346

12.504

119513

7.5688

120243

12

120603

24

6.973684

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80594
<b>Description:</b> Fwd Beam		<b>Part Number:</b>	D4275-1
<b>Inspection Dwg:</b> D4275	<b>Rev:</b> A	<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.750	/		Vern	SL-3
26.700	+/-0.010	26.700	/		m-tape	
Ø0.381	+0.000/-0.001	.381	/		gauge pins	
8.280	+/-0.010	8.280	/		H-G	
1.44	+/-0.030	1.44	/		"	
0.95	+/-0.030	.949	/		"	
3.50	+/-0.030	3.500	/		Vern SL-3	
13.28	+/-0.030	13.28	/		m-tape	
13.50	+/-0.030	13.50	/		"	
9.25	+/-0.030	9.25	/		"	
5.00	+/-0.030	5.00	/		Vern SL-3	
0.75	+/-0.030	.750	/		"	
2.75	+/-0.030	2.75	/		"	
3.00	+/-0.030	3.00	/		"	
1.250	+/-0.010	1.250	/		H-G	
4.50	+/-0.030	4.50	/		Vern SL-3	
0.734	+/-0.010	.734	/		"	
0.108	+/-0.010	.106	/		H-G	
39.48	+/-0.030	39.48	/		m-tape	
0.95	+/-0.030	.949	/		Vern SL-3	
0.60	+/-0.030	.598	/		"	
1.750	+/-0.010	1.750	/		"	
2.700	+/-0.010	2.699	/		"	
1.10	+/-0.030	1.100	/		"	
1.25	+/-0.030	1.248	/		"	
0.900	+/-0.010	.899	/		H-G	
0.75	+/-0.030	.749	/		"	
0.250	+/-0.010	.250	/		"	
3.000	+/-0.010	3.000	/		Vern SL-3	
1.500	+/-0.010	1.500	/		"	
Ø0.191	+0.005/-0.001	.193	/		"	

W/O:		WORK ORDER CHANGES					
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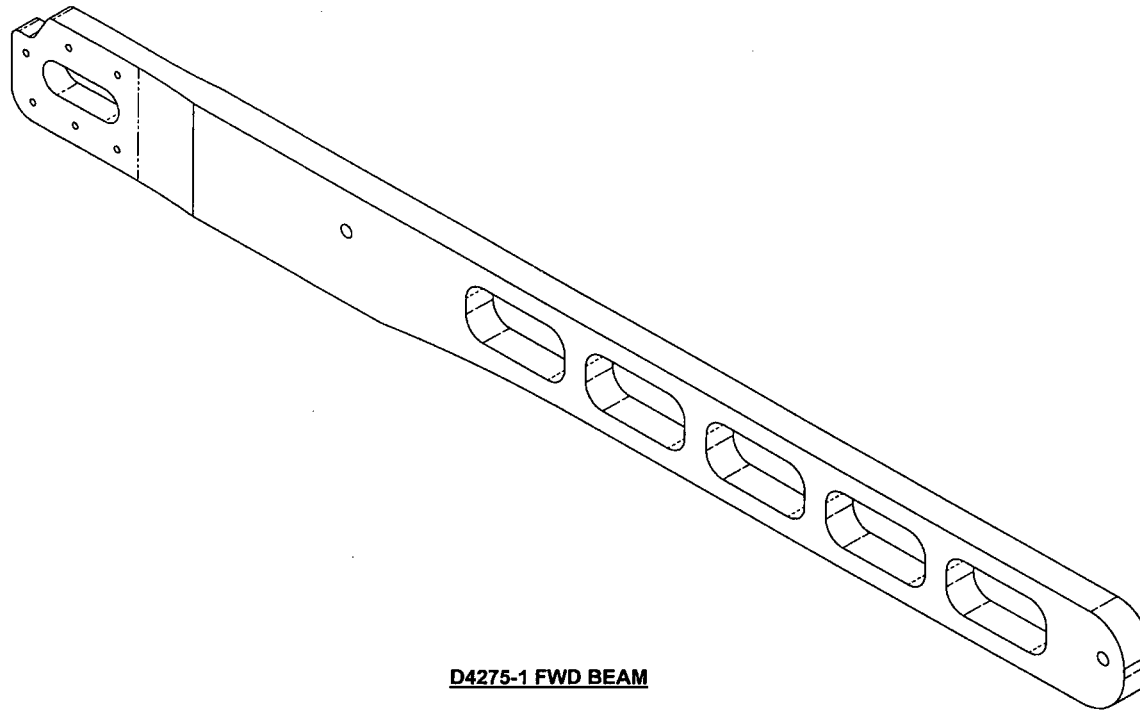
**Dart Aerospace Ltd**

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**D4275-1 FWD BEAM**

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO APPROVAL  
 WITH REVISION  
 WORK ORDER  
 NO. **80594 HLT**  
**12/02/23**

**RELEASED**  
 2010-11-30

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
 OR ASTM B211 OR ASTM B221  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.29 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4275</b>	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>FWD BEAM</b>	NTS
DATE	10.11.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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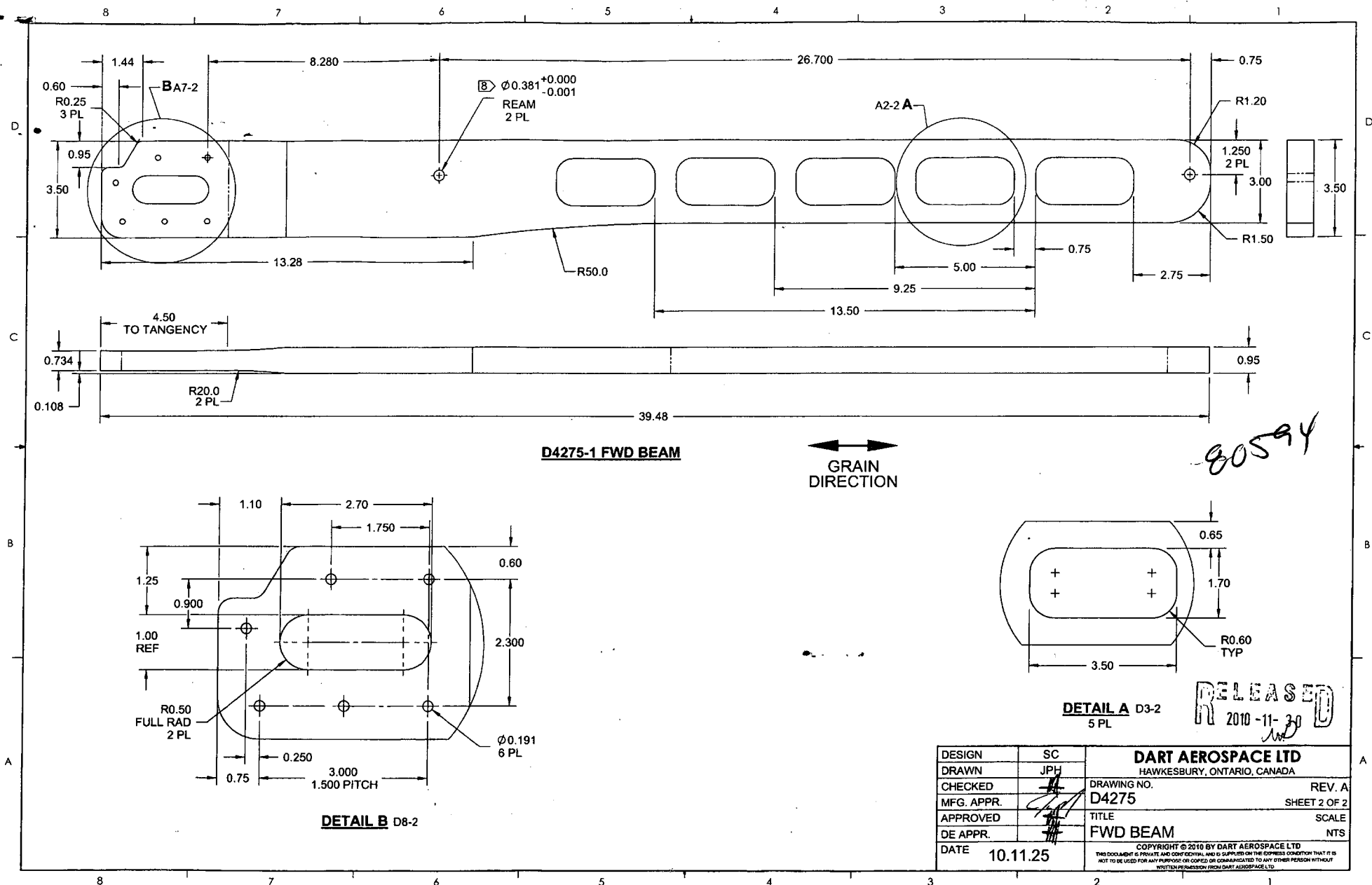
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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